

Date: Monday, 10/30/2006 4:14:55 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEB ASSEMBLY
 Job Number : 29225
 Estimate Number : 10194
 P.O. Number : *NIA*
 This Issue : 10/30/2006 S.O. No. : *NIA*
 Prsht Rev. : NC
 First Issue : *NIA* Type : PURCHASED PARTS
 Previous Run : 26017
 Written By : _____
 Checked & Approved By : _____
 Comment : Est: D 04.06.10 Reformat; Changed Step 2 KJ/JLM

Part Number : D2174041
 Drawing Number : D2174-041
 Project Number : N/A
 Drawing Revision : UNDER REVIEW
 Material : *NIA*
 Due Date : 11/24/2006 Qty: 14 Um: Each

UNDER REVIEW 06.10.31
REVIEW

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D21741 Web



Comment: Qty.: 1.0000 Each(s)/Unit Total : 14.0000 Each(s)
 Web

Qty	Part Number	Description	Batch
1	D2174-1	Web	<i>B22027</i>

2.0 D21751 Angle LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 14.0000 Each(s)
 Angle LH

Qty	Part Number	Description	Batch
1	D2175-1	Angle	<i>B24495</i>

3.0 D21752 Angle RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 14.0000 Each(s)
 Angle RH

Qty	Part Number	Description	Batch
1	D2175-2	Angle	<i>B24496</i>

4.0 MS20470AD46 Rivet, Universal Head



Comment: Qty.: ~~25~~ 322.0000 Each(s)/Unit Total : 322.0000 Each(s)
 Rivet, Universal Head

Qty	Part Number	Description	Batch
19	MS20470AD4-6	Rivet	<i>M18615</i>

4 ANS26C832R14 Screw *M9216*

4 AN960JDB Washer *M102455*

4 MS21042208 Nut *M101438*


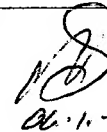


8.2 INSPECT WORK.

06/11/20 Form: rprocess

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/11/30
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06/11/22	5	Open hole at Ø.172 hole to small Ø.130		Open hole at Ø.172	SB 06/11/23	 06.11.23		 06.11.23

NOTE: Date & initial all entries

Date: Monday, 10/30/2006 4:14:56 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEB ASSEMBLY

Job Number: 29225

Part Number: D2174041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per Dwg D2174-041

2- Identify as D2174-041

SB 06/11/23 20

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06/14/23 (20)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FL 06/11/24 (20)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

06/14/22 (20)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57220

06/14/27 (20)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/11/30 (20)

Job Completion



06/11/28

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

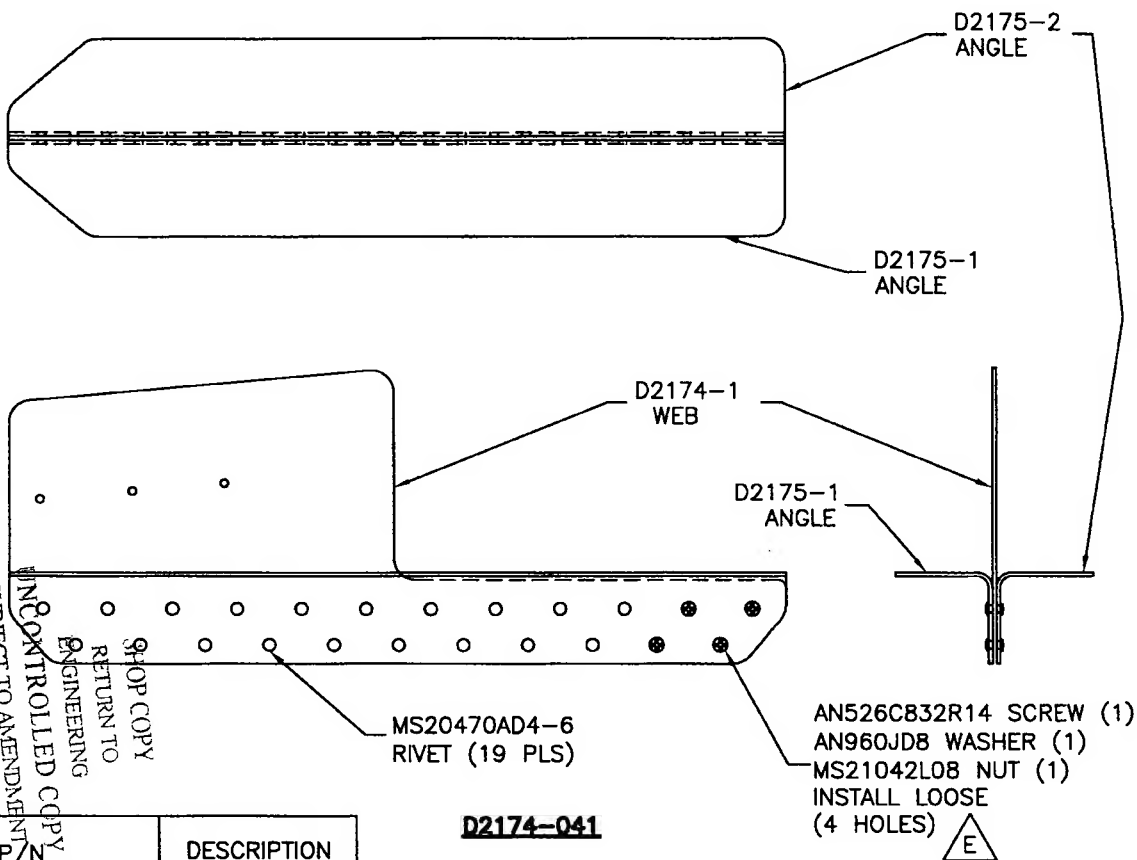
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
RF	CE	DRAWING NO.	REV. E	
CHECKED PH	APPROVED CH	D2174	SHEET 1 OF 2	
DATE 06.09.25	TITLE WEB ASSEMBLY	SCALE 1:3		
A	95.10.25	NEW ISSUE		
B	96.01.18	RE-DRAWN		
C	00.09.11	UPDATE FINISH SPEC.		
D	04.06.03	RE-DESIGN		
E	06.09.25	INC 4 HOLES TO Ø0.172; CHG HARDWARE		



D2174-041

QTY	P/N	DESCRIPTION
X	D2174-041	WEB ASSEMBLY
1	D2174-1	WEB
1	D2175-2	ANGLE
1	D2175-1	ANGLE
4	AN526C832R14	SCREW
4	AN960JD8	WASHER
4	MS21042L08	NUT
19	MS20470AD4-6	RIVET

NOTES:

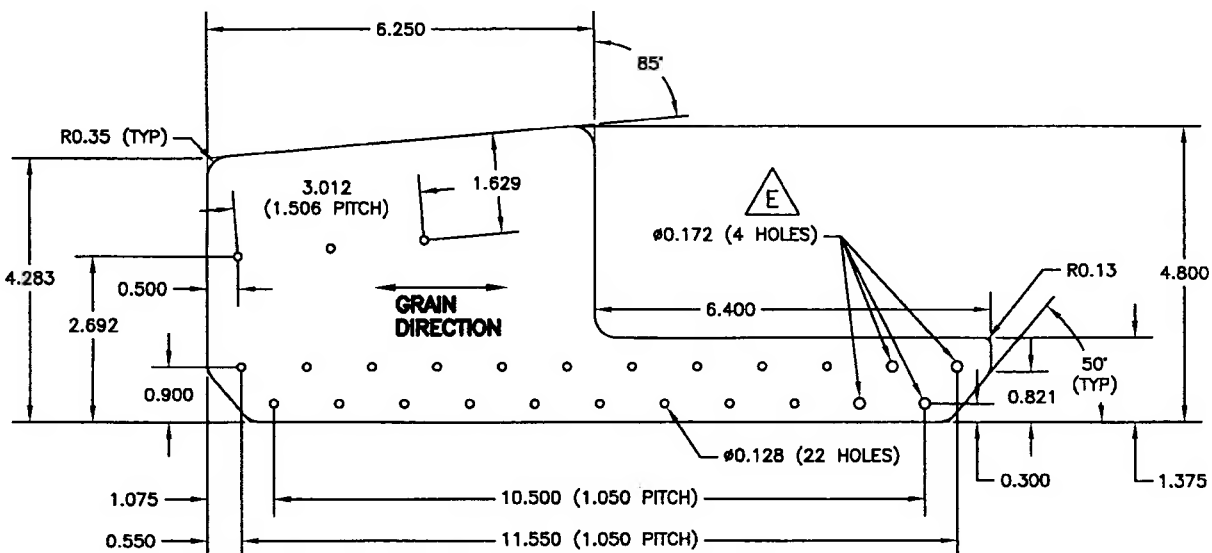
- 1) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) IDENTIFY WITH P/N D2174-041 USING FIND POINT PERMANENT INK MARKER.

RELEASED
06 10 13



DESIGN	DRAWN BY	DART AEROSPACE LTD
RF	CE	HAWKESBURY, ONTARIO, CANADA
CHECKED PH	APPROVED [Signature]	DRAWING NO. D2174
DATE 06.09.25	TITLE WEB	REV. E SHEET 2 OF 2
		SCALE 1:3

RELEASED
06.10.23



D2174-1

NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-200/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
BREAK ALL SHARP EDGES 0.005 TO 0.010
ALL DIMENSION ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 29225